

Work Order ID 121856

121856

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Wednesday, July 02, 2014 3:37:20 PM

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 7/02/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 140704 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00							
Packaging									

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab									

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 128638

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

10 FF SEP 24 2014

10 FF SEP 24 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	1996								
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS
130									38
QC	Memo	0.00				(10)			9-89 14-9-25
Quality Control									
140	Identify as per dwg & Stock Location: <u>54366</u>	0.00							
140									
Packaging	Memo	0.00				10		NO	14/09/25
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-25

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Work Order ID: 121856

121856

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV:B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	52.0000	1	10			
D4775-1									**			FF	SEP 24 2014
Strut Tube													

Location	Loc Qty	Loc Code
GA	32	
113361	10	
113841	1	
115177	20	
117205	1	
ST266	20	
116120	20	

D4777-1		Manufactured	No			110	Each	45.0000	1	10			
D4777-1									**			FF	SEP 24 2014
Rod End Bearing													

Location	Loc Qty	Loc Code
ST122 124299	44	
115995	28	
116963	16	
ST123	1	
113699	1	

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Work Order ID: 121856

121856

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 10.00

Required Qty: 10.00

D4776-1 Manufactured No

110 Each 52.0000 1 10

D4776-1

Basket Strut Clevis

FF SEP 24 2014

Location	Loc Qty	Loc Code
ST120	10	
120234	10	
ST122	41	
113290	1	
<u>115946</u>	40	
ST123	1	
110934	1	

10

D4776-5 Manufactured No

110 Each 203.0000 4 40

D4776-5

Spacer

FF SEP 24 2014

Location	Loc Qty	Loc Code
ST122	198	
113369	31	
<u>116137</u>	167	
ST123	5	
111095	3	
112597	1	
117247	1	

40

AN3-10A Purchased No

110 Each 410.0000 2 20

AN3-10A

Bolt

FF SEP 24 2014

Location	Loc Qty	Loc Code
ST351	110	
m127817	35	
m128403	75	
ST511	300	
m128813	150	
<u>m128936</u>	150	

20

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Picklist Print

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Work Order ID: 121856

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Parent-Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

110

Each

5,402.000

2

20

MS21042L3

FF SEP 24 2014

Nut

Location

Loc Qty

Loc Code

ST307

5402

123900

955

M126333

10

M127410

13

M127831

41

M128401

48

M128754

4335

20

MS21209-F615

Purchased

No

110

Each

123.0000

1

10

MS21209-F615

FF SEP 24 2014

Heli-Coil

Location

Loc Qty

Loc Code

GA

73

125097

5

m128537

68

ST301

50

m129499

50

10

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